

Work Order ID 69549

Wednesday, May 11, 2011 3:17:12 PM



Page 1

Item ID: D3650-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Panel

Start Date: 5/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3650	Rev C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3650								
<i>304.008</i>	Dwg Rev: <i>C</i>								
	Prog Rev: <i>C</i>								
	2-Deburr if necessary								

11-5-18

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11-5-18

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5/11/11

(Signature)

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3650

0.00

0.00

SB 11/05/127

(5)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 11/05/130

(5)

150



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D3650

0.00

0.00

SB 11/06/02 (5)

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 11/06/02

K5

170



Packaging

Packaging

Identify as per dwg & Stock Location: 189

0.00

0.00

Memo

11/6/13 SP 50

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/6/06 JG
C 21/06/06

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Picklist Print

Wednesday, May 11, 2011 3:17:18 PM

Page 1

Work Order ID: 69549

Parent Item: D3650-5

Parent Item Name: Fwd Panel





Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3893-1  DOUBLER		Manufactured	No				Each	14.0000		4			
<div> <div>Location</div> <div>GA</div> <div>45377</div> <div>52689</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>2</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
MS21062-3K  Nut Plate		Purchased	No			110	Each	66.0000	2	8			
<div> <div>Location</div> <div>ST302</div> <div>109590</div> <div>117343</div> </div> <div> <div>Loc Qty</div> <div>66</div> <div>16</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3650-7  Seal		Manufactured	No			150	Each	2.0000	1	4			
<div> <div>Location</div> <div>st073</div> <div>62008</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3650-9  Angle		Manufactured	No			150	Each	2.0000	1	4			
<div> <div>Location</div> <div>ST189</div> <div>53489</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

ES 11/06/02

ES 11/06/02

ES 11/06/02

ES 11/06/02

B69998 (B)

B69999 (3)

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 69549

Parent Item: D3650-5

Parent Item Name: Fwd Panel

Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

M304S26GA

Purchased

No

150

sf

15.0000

0.813

3.423158



304/316 0.018 SHEET



B11-5-18

Location

Loc Qty

Loc Code

MAT020

15

109398

3

112885

12

112885

MS20427M3-3

Purchased

No

150

Each

1,058.000

8

32



Rivet



ES 11/06/02

Location

Loc Qty

Loc Code

ST318

1058

117206

1058

40

MS21060-3K

Purchased

No

150

Each

57.0000

2

8



Nut Plate



ES 11/06/02

Location

Loc Qty

Loc Code

ST301

20

117423

20

ST302

37

116857

37

10

NAS9307/M-4-03

Purchased

No

150

Each

195.0000

12

48



RIVET



ES 11/06/02

Location

Loc Qty

Loc Code

ST281

195

109545

195

60

Wednesday, May 11, 2011 3:17:19 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09549

11-054

MS21062-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

MS21060-3K NUTPLATE
MS20427M3-3 RIVET, 2 PL
2 PL

NAS1149CN432R
WASHER, REF

0.07

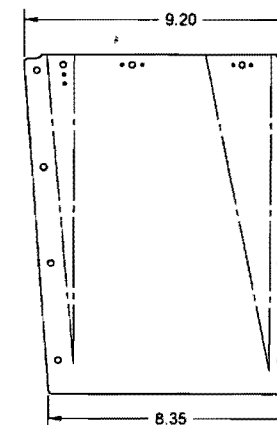
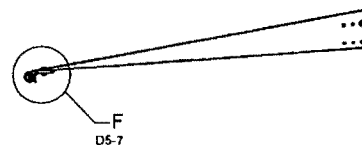
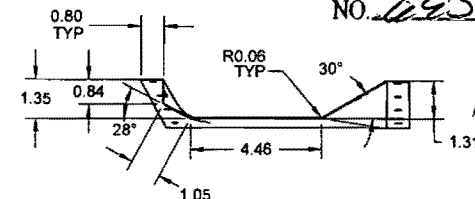
0.74

D3650-5B FWD PANEL
BENT PART
REF

MS20615-4M5
RIVET, REF

D3650-7-8.19 SEAL
D3650-9 ANGLE

DETAIL F
SCALE 3.5X



DEO ATTACHED

D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

RELEASED

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

D3650-9 REF

D3650-5B
FWD PANEL
BENT PART

D3650-7-8.19
REF

CENTRE D3650-7/-9 ON D3650-5B &
TRANSFER Ø0.129 (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
MS20615-4M5 RIVET
NAS1149CN432R WASHER
12 PL

C

D3650-5 FWD PANEL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

UNDER REVIEW
UP 07-05
OK 07-06-24

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

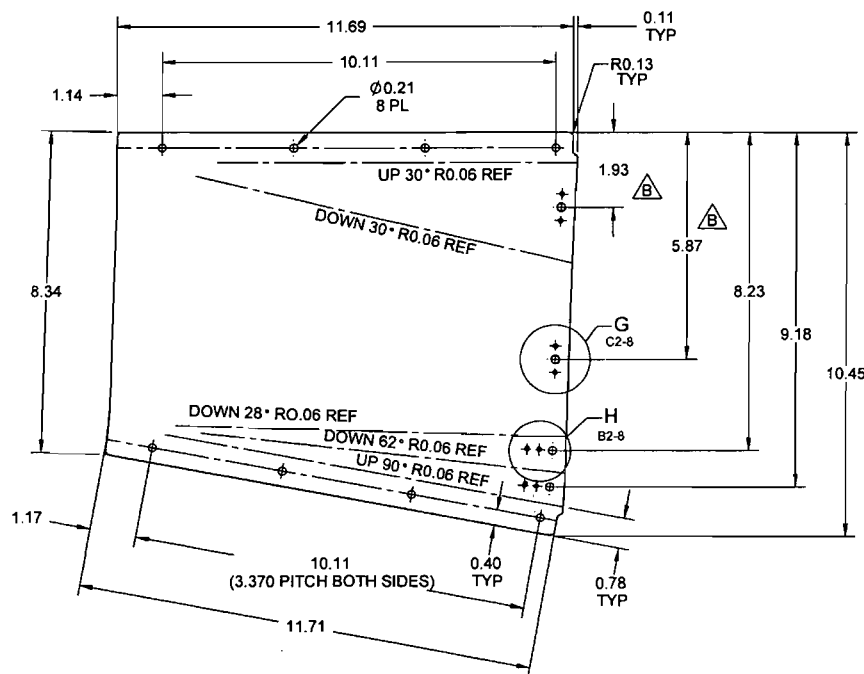
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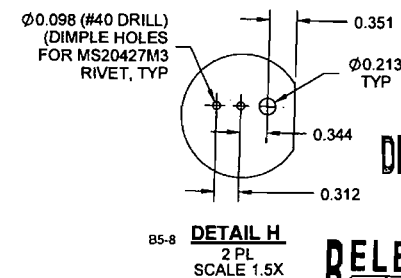
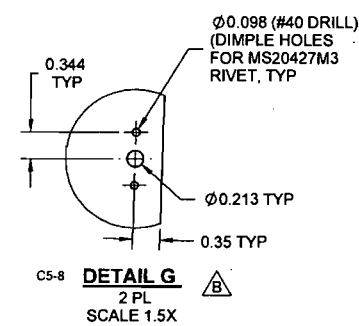
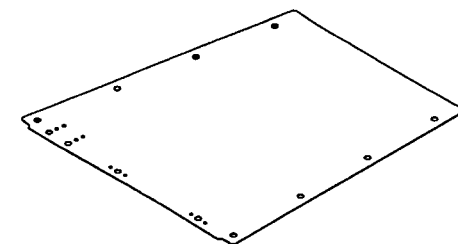


D3650-5F FLAT PATTERN

NOTES:





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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

UNDER REVIEW
[Signature]
 08.10.14



DEO ATTACHED

RELEASED
[Signature]

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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